

Work Order ID 129028

129028

Page 1

Wednesday, January 28, 2015 8:49:25 AM

Item ID: D4131-043

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assy

Start Date: 1/28/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/28/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 15-01-28 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4131	C

100 FLOW WATER JET 0.00

100

Waterjet

Memo

FLOW CNC Waterjet

1-Cut D4131-7 as per Dwg

6061.063

Dwg Rev: C

Prog Rev: C

2-Deburr as required

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

Quality Control

120 QC8- Inspect parts - second check 0.00

120

QC

Memo

Quality Control

DAS

38

9-89

FEB 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129028

129028

Page 2

Wednesday, January 28, 2015 8:49:25 AM

Item ID: D4131-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler Assy

Start Date: 1/28/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/28/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					9x			15/02/12
Small Fab	Memo	0.00							
Small Fab	COUNTER SINK AS PER DWG								
	Deburr if necessary.								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									

DAS
36
9-89

DAS
38
9-89

FEB 13 2015

9 15-3-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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129028

Wednesday, January 28, 2015 8:49:25 AM

N900040100

Stop *NS2*

8

8

Reference:

Run Start *NR1*

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

161 QC7-Inspect Chemical Conversion Coat

0.00

161

0.00

QC

Memo

Quality Control

0.00

165

0.00

Small Fab

Memo

Small Fab

ASSEMBLE NUT PLATES AS PER DWG

0.00

166

166

0.00

QC

Memo

Quality Control

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order ID 129028

Wednesday, January 28, 2015 8:49:25 AM

129028

Page 4

Item ID: D4131-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler Assy

Start Date: 1/28/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/28/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

0.00

Packaging

9

MAR 10 2015

DAS
98
9-89

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

ML5 1503-11

15.3-10

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, January 28, 2015 8:49:30 AM

Page 1

Work Order ID: 129028

129028

Parent Item: D4131-043

D4131-043

Parent Item Name: Doubler Assy

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	290.4152	0.1807	2			

M6061T6S 063

6061-T6 .063 Sheet

**

01/15/02/12

Location	Loc Qty	Loc Code
MAT021	290.4152	
M128941	18.5	
M129845	30.8353	
M130096	25	
M130745	24.0799	
M131322	96	
M131383	96	

MS20426AD3-3

Purchased

No

165

Each

727.0000

8

**

DAS
28
9-89

MAR 09 2015

MS20426AD3-3

RIVET

Location	Loc Qty	Loc Code
ST313	727	
M128754	727	

MS21069L3

Purchased

No

165

Each

80.0000

4

**

DAS
28
9-89

MS21069L 3

ANCHOR NUT

Location	Loc Qty	Loc Code
ST301	80	
m130799	30	
m131187	50	

6.72 x m131624

3/36

36

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order: 129028
Description: Plate		Part Number: D4131-7
Inspection Dwg: D4131	Rev: <i>CAM</i>	Page 1 of 1

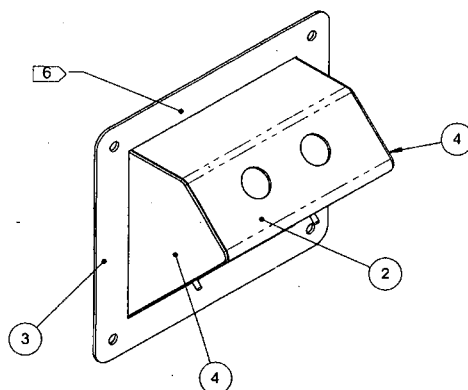
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0.098	/		V-dm-02	
Ø0.191	+0.005/-0.001	Ø0.190	/		Tape	
0.500	+/-0.010	.500	/			
0.59	+/-0.030	.590	/			
0.405	+/-0.010	.399	/			
4.600	+/-0.010	4.598	/			
3.64	+/-0.030	3.642	/			
4.81	+/-0.030	4.809	/			
4.10	+/-0.030	4.105	/			
5.41	+/-0.030	5.414	/			
0.66	+/-0.030	.662	/			
4.000	+/-0.010	4.003	/			
0.063	+/-0.010	.062	/			

Measured by: <i>DM</i>	Audited by: <i>DAS</i>	Preliminary Approval:
Date: 15/02/12	Date: FEB 12 2015	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	
B	12.07.31	Dimensions updated per Dwg Rev B	KJ	<i>[Signature]</i>

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4131-041	MANIFOLD ASSEMBLY
2	1	D4131-045	BASE ASSEMBLY
3	1	D4131-1	FRONT PLATE
4	2	D4131-5	SIDE PLATE



D4131-041 MANIFOLD ASSEMBLY

129028 MWS
1501-28

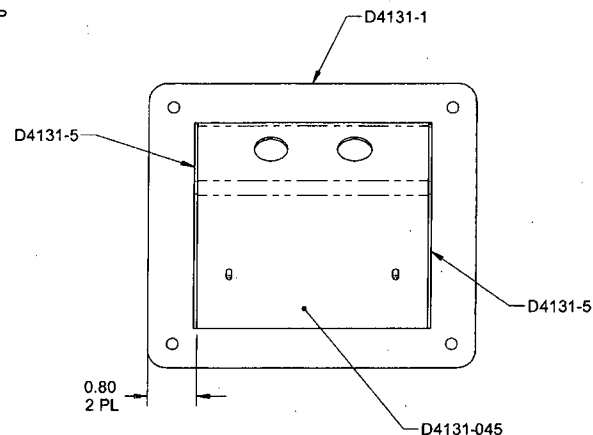
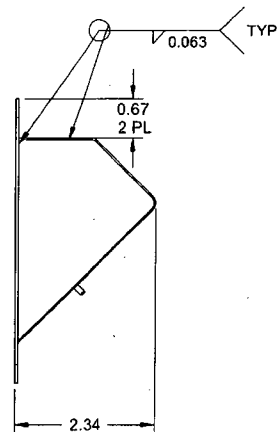
RELEASED
2014 -10- 20
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.66 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4131	REV. C
MFG. APPR.	JFS	SHEET 1 OF 10	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MANIFOLD ASSEMBLY	NTS
DATE	14.09.08	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED



D4131-041 MANIFOLD ASSEMBLY
(AUXILIARY VIEW)

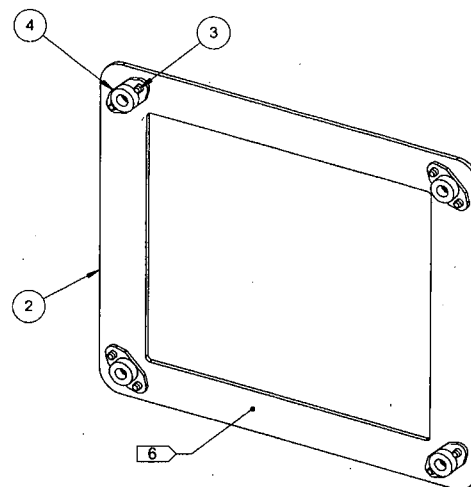
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.66 lbs
- 8) WELD PER DART QSI 004

RELEASED
2014-10-20

APPROVED	DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4131	SHEET 2 OF 10
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MANIFOLD ASSEMBLY	NTS
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	SIDE PLATE
3	8	MS20426AD3-3	RIVET, SOLID, CSK
4	4	MS21069L3	NUT PLATE, SELF-LOCKING



D4131-043 DOUBLER ASSEMBLY

NOTES:

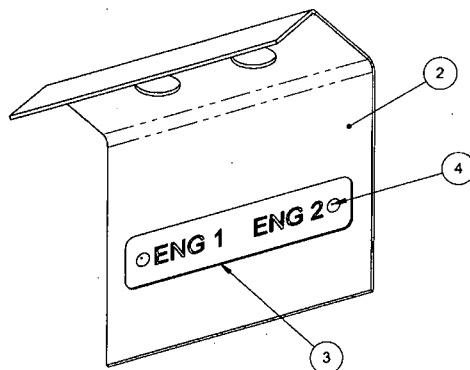
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

RELEASED
2014-10-28
M

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DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
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CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4131	SHEET 3 OF 10
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ITEM	QTY .045	P/N	DESCRIPTION
1	X	D4131-045	BASE ASSEMBLY
2	1	D4131-3	BASE
3	1	D4131-9	LABEL PLATE
4	2	MS20615-3M3	RIVET, SOLID, PAN-HEAD



D4131-045 BASE ASSEMBLY

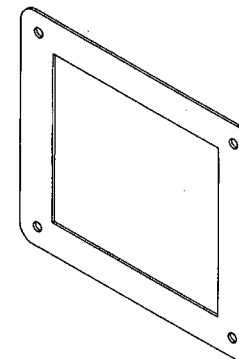
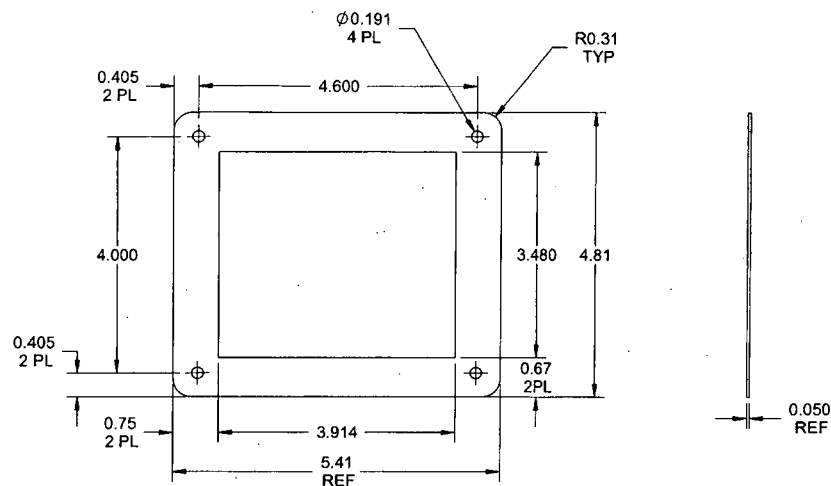
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

RELEASED
2014-10-20
WJ

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DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4131	SHEET 4 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	# MANIFOLD ASSEMBLY	NTS
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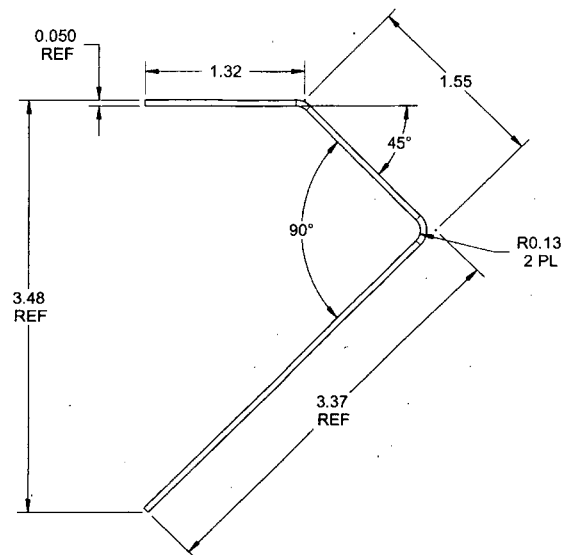
D4131-1 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

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2014-10-20

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	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4131	SHEET 5 OF 10
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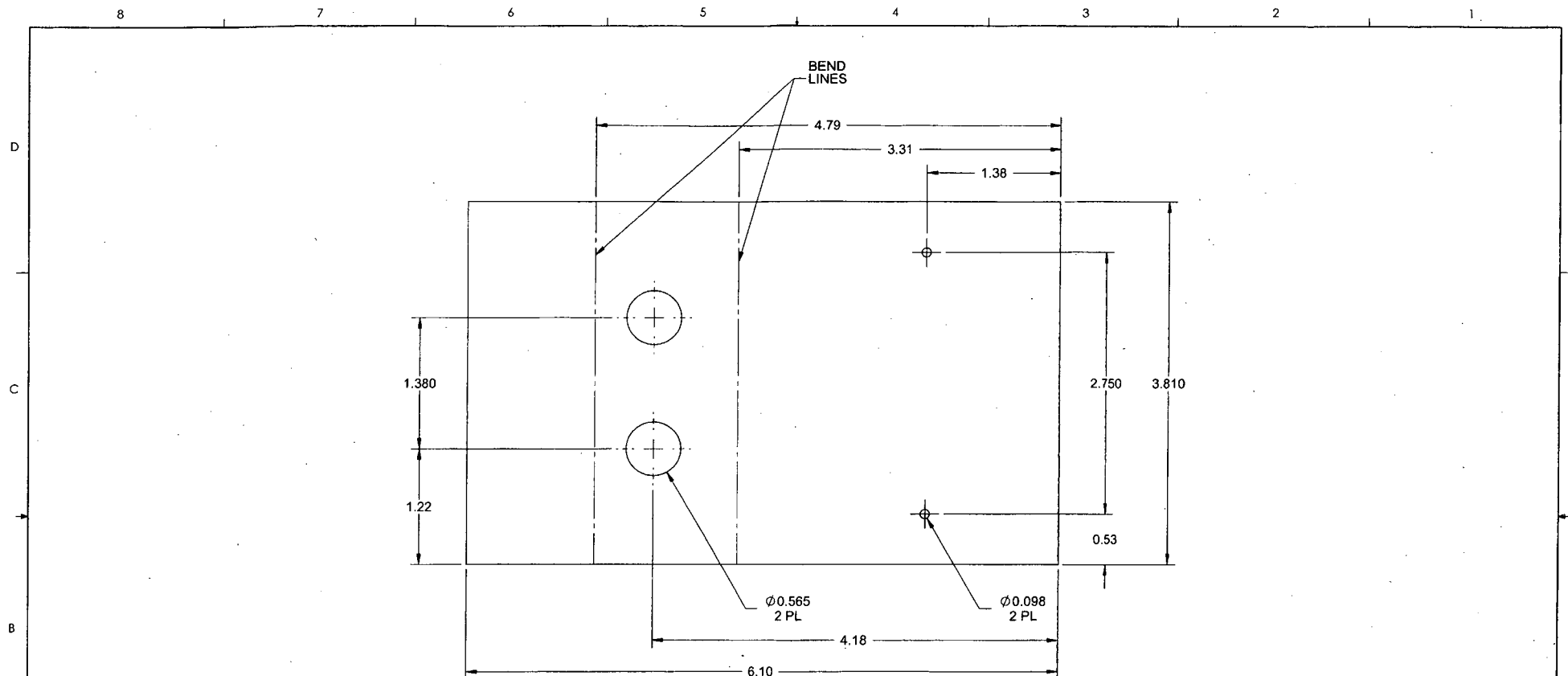
D4131-3 BASE
(MAKE FROM D4131-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

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2014-10-20

APPROVED	DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4131	SHEET 6 OF 10
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MANIFOLD ASSEMBLY	NTS
DATE			14.09.08	
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D4131-3F FLAT PATTERN

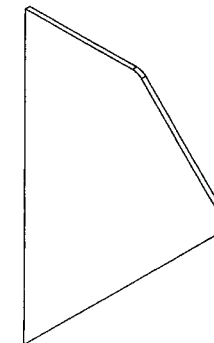
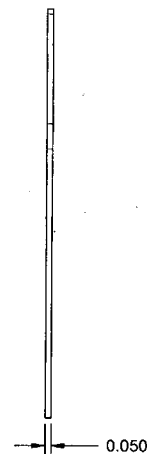
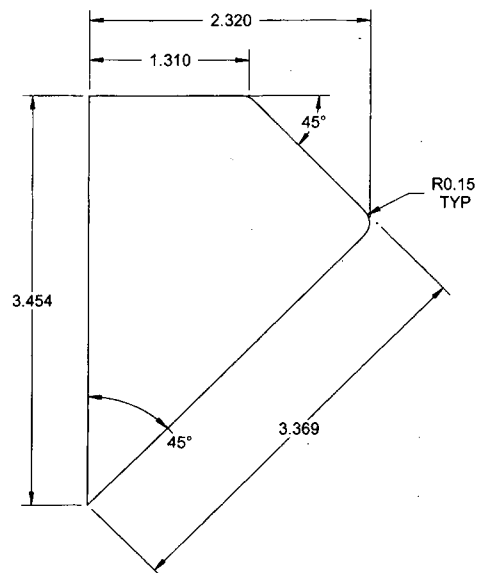
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

RELEASED
2014-10-20

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DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4131	REV. C
MFG. APPR.	JFS	SHEET 7 OF 10	
APPROVED	HS	TITLE	SCALE
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D4131-5 SIDE PLATE

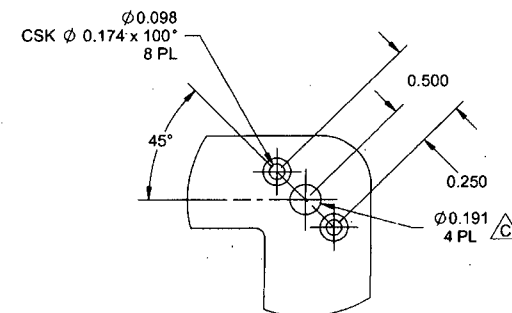
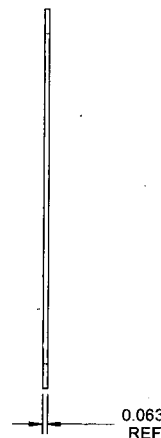
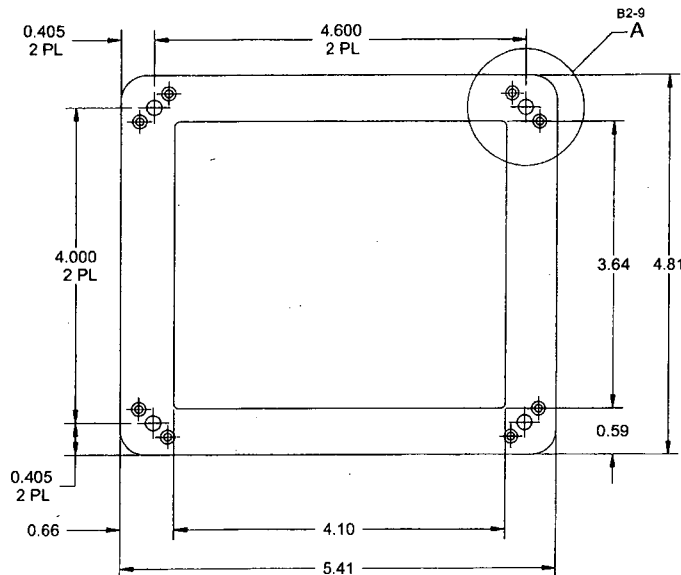
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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2014-10-20

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DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4131	REV. C
MFG. APPR.	JFS		SHEET 8 OF 10
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DETAIL A D5-9
TYPICAL

D4131-7 PLATE

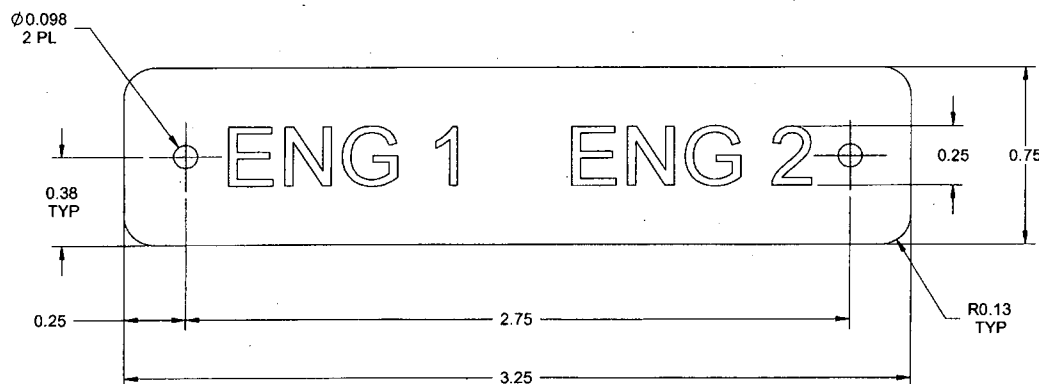
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS4027
OR ASTM B209
PER DART SPEC. M6061T6S0.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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2014-10-20

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	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4131	SHEET 9 OF 10
	APPROVED	HS	TITLE	SCALE
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ENG 1 ENG 2



D4131-9 LABEL PLATE

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2014-10-20
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.030 (22 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S22GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4131	REV. C
MFG. APPR.	JFS	SHEET 10 OF 10	
APPROVED	HS	TITLE	SCALE
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